

Work Order ID 63228

Page 1

Monday, October 25, 2010 2:38:50 PM

Item ID: D3836-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 10/25/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/10/25 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3836	Rev A	

100



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open
to finish size as per dwg D38365- weld D2327-3 spacer bushing as per dwg D3836
A/R ER316 S.S. Rod Batch: 111585

6- grind weld flush where indicated on dwg

130



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63228

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Monday, October 25, 2010 2:38:50 PM

Item ID:	D3836-041	Accept		Setup	Start		
Revision ID:						Stop	
Item Name:	Rib Assembly (Basket Lid, LH)						
Start Date:	10/25/2010	Start Qty: 2.00		Cust Item ID:			
Required Date:	10/29/2010	Req'd Qty: 2.00		Customer:			
Reference:							
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S.01u124			(2)	0		
150 Packaging Packaging	Identify as per dwg & Stock Location: WA Memo	0.00 0.00	SAD	16-11-24		(2)	0		
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				CK 10/11/25 MF	0	10-11-25	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, October 25, 2010 2:38:55 PM

Work Order ID: 63228



Parent Item: D3836-041



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 10/25/2010

Required Date: 10/29/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	20.0000	1				

Spacer Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	20	
58974	1	
60320	1	
60952	11	
62108	7	

M304TS0.750W.065



Purchased

No

100 f 468.6990 1.7808 3.749053



SAD 10-11-07

304 SQ Tube .75x.75x.065W

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

MAT	315.30255	
112398	0	
114482	0.0002	
115494	32.8937	
115593	282.40865	
WA	153.396485	
114520	0.527385	
115274	16.027	
115901	136.8421	

3.7491

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

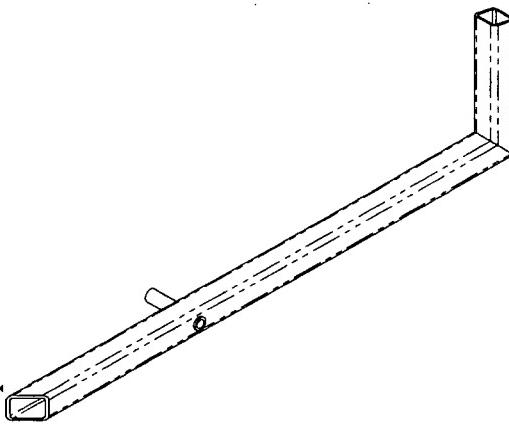
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

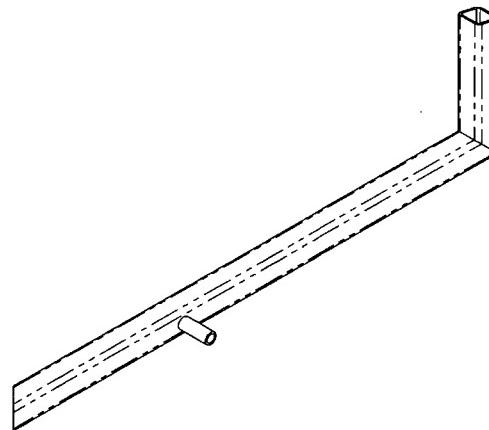
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

A

NOTES:

- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: .0005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH
 - 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

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SUBJECT TO AMENDMENT

WORK ORDER
NO. 43228
21/0-10-25

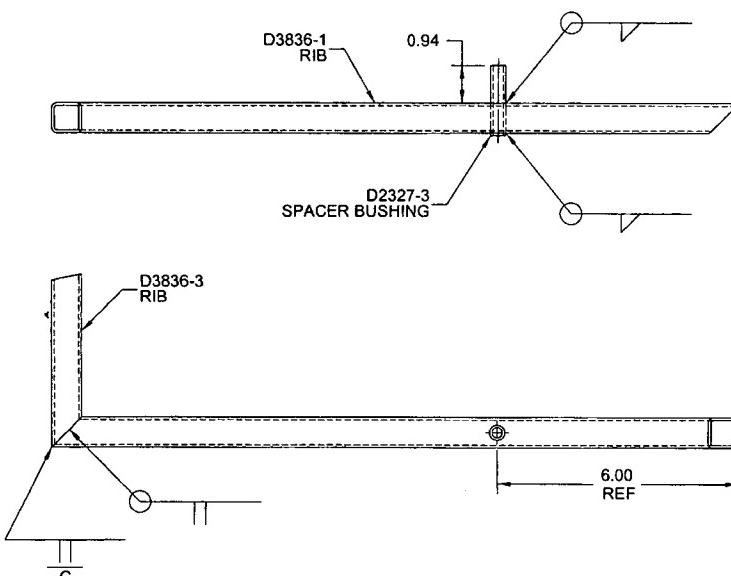
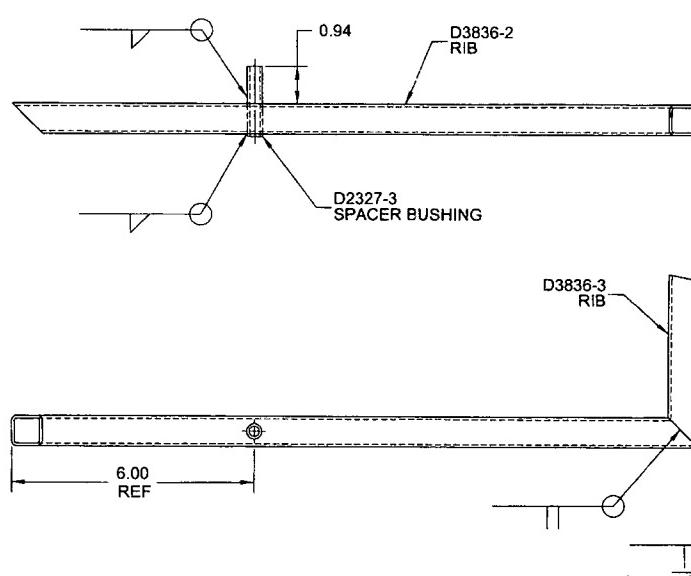
RELEASER
SCHWAB

A	NEW ISSUE	MB	08.09.24
REV.		DESCRIPTION	BY DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D3836	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		RIB ASSY (BASKET LID)	NTS
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DATE	08.09.24		

8 7 6 5 4 3 2 1

D

D

D3836-041 RIB ASSY (BASKET LID, LH)D3836-042 RIB ASSY (BASKET LID, RH)

W/063228

RELEASED
08/11/18 JMF

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D3836
MFG. APPR.		REV. A
APPROVED	<i>[Signature]</i>	SHEET 2 OF 3
DE APPR.		TITLE RIB ASSY (BASKET LID)
DATE	08.09.24	SCALE NTS

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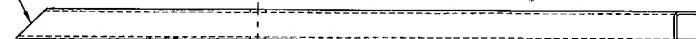
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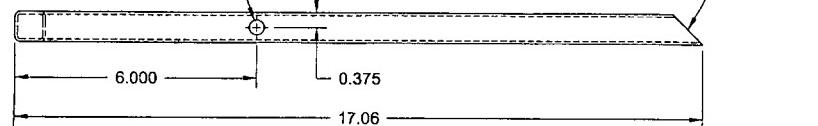
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8 7 6 5 4 3 2 1

0.75 X 45°
CHAMFER

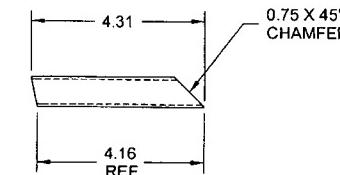


$\phi 0.375^{+0.020}_{-0.000}$ THRU



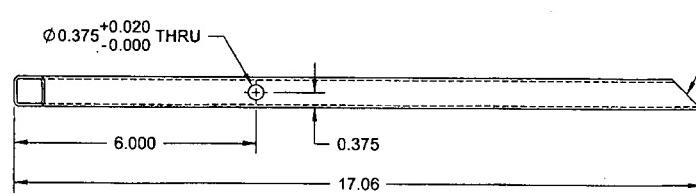
D3836-1 RIB

0.75 X 45°
CHAMFER

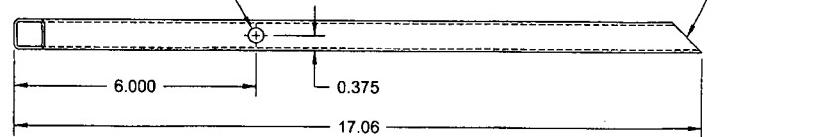


D3836-3 RIB

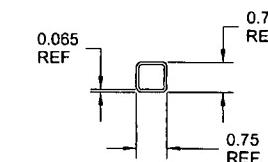
0.75 X 45°
CHAMFER



$\phi 0.375^{+0.020}_{-0.000}$ THRU



D3836-2 RIB



TYPICAL SECTION
VIEW

RELEASER
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.75W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

8 7 6 5 4 3 2 1

DESIGN	<u>b</u>	DART AEROSPACE LTD	
DRAWN	<u>b</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>ASS</u>	DRAWING NO.	
MFG. APPR.	<u>APR</u>	D3836	REV. A
APPROVED	<u>APR</u>	SHEET 3 OF 3	
DE APPR.	<u>APR</u>	TITLE	SCALE
DATE	08.09.24	RIB ASSY (BASKET LID)	NTS
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